

5/45

DART AEROSPACE LTD	Work Order:	24669
Description: Extrusion	Part Number:	D2500-1-190
Drawing: D2500 Rev. F1	Qty:	80

Step	Location	Procedure	By	Date	qty
1	DC	Issue Traveller	[Signature]	05/10/26	
2	PG	Issue P/O: <u>2008873</u> a) Extrude as per Dwg D2500 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 190" long g) Bon L Canada Inc. tool # 897105 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	[Signature]	07/0/27	80
3	RG	Inspect for transit damage Ensure certification are attached	CL	05/11/15	77
4	QC6	Inspect dimensions per Dwg D2500 Check Pull test per Dwg D2500 for compliance page attached. Check hardness with Webster tester	[Signature]	16-04-04	77
5	ST	Identify & stock	[Signature]	16-04-04	77
6	AC	Cost / part	[Signature]	16/05/04	27
7	DC	Close W/O Inspect level 21	[Signature]	26/04/05	27

Rev	Date	Change	Revised By	Approved
E	01.03.29	Changed part number to -190	EC	
F	01.10.29	Revised Step 2	SM	
G	02.09.05	Added DSK 066	KJ RF	[Signature]

RELEASED
02/09/17 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 2/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DJY</i>	DRAWN BY <i>DJY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DJY</i>	DRAWING NO. D2500	REV. F SHEET 1 OF 2
DATE 97:09:29		TITLE EXTRUSION	SCALE NTS
A	96:03:19	NEW ISSUE	
B	96:03:24	CHANGE INTERNAL WEB	
C	96:04:26	ADD D2500-3 WEB	
D	96:10:07	ADD MATERIAL PROPERTIES	
E	96:10:24	CHANGE MATERIAL TEMPER	
F	97:09:29	CHANGE MAT. TO 6061-T6	
FI	01.04.17	ADD NOTES 4 & 5 <i># UP</i>	

RELEASED
97/10/06 DS

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX

3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

4. FOR D2500-1, PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-1-190 IS 190" LONG)

D2500-1 EXTRUSION MANUFACTURED FROM: a) BON L DIE # 897105 → PREFERRED
b) CARADON MIDEAST DIE # PAH-28030
c) CARADON MTL DIE # MH-18868

5. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-3-100 IS 100" LONG)

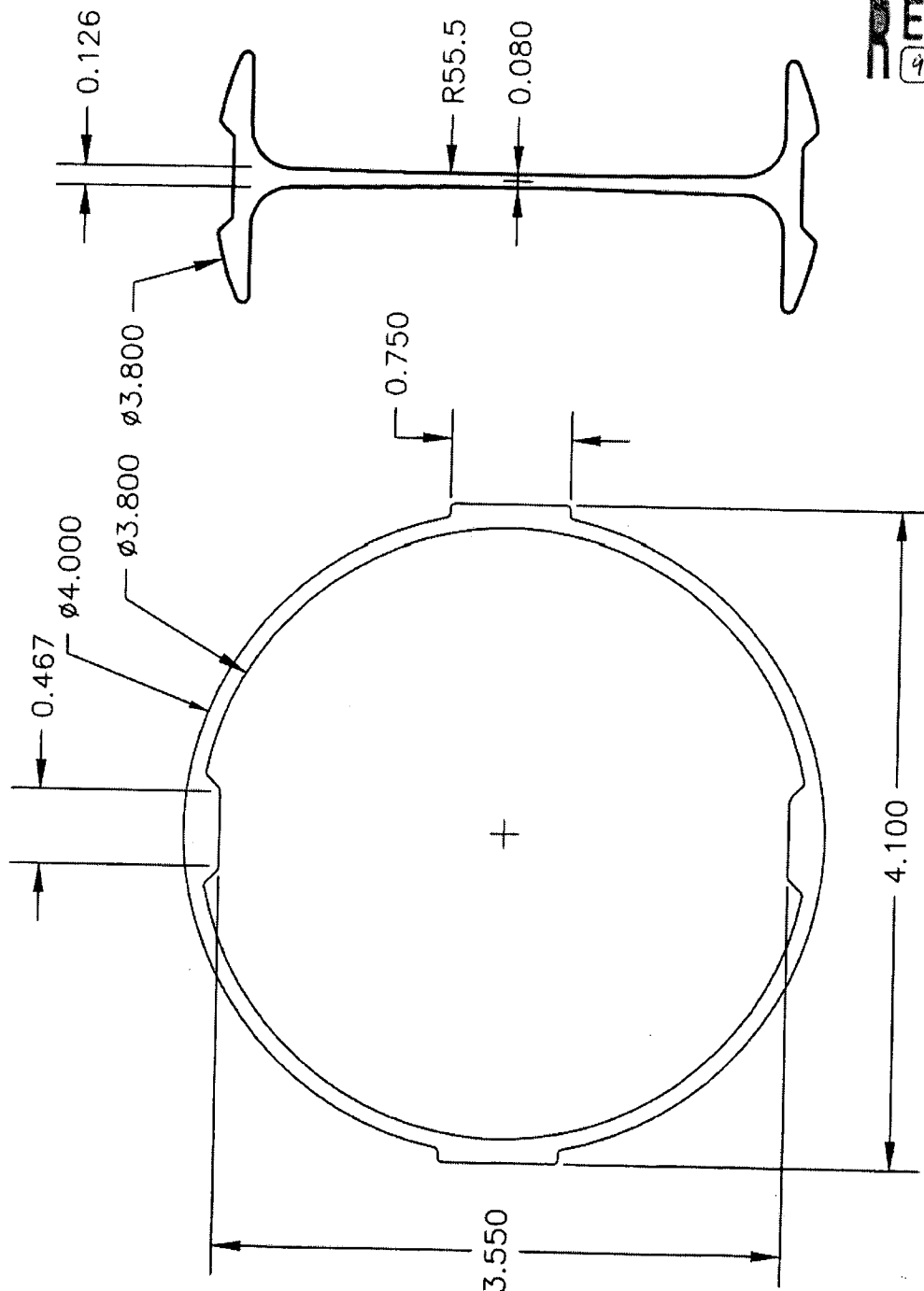
D2500-3 EXTRUSION MANUFACTURED FROM CARADON INDALEX DIE # MS-18867

UNCONT
SUBJECT TO



DESIGN <i>MBJ</i>	DRAWN BY <i>MBJ</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>MBJ</i>	DRAWING NO. D2500	REV. F SHEET 2 OF 2
DATE 97:09:29		TITLE EXTRUSION	SCALE 1:1

RELEASED
97/10/06 DS



D2500-3

D2500-1

WORK ORDER

NO. 24669

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 25, 2005
04:04 pm

Work Order No	: 0024669	Department Code:	
Project Name	: D2500-1-190	Burden Flags	: NNNNNNNN
Project For	: WK545	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2500-1-190	Invoice Number	:
Description	: Ext'n - 'I' Beam Tube 4"	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 80	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 10-25-05		
Est Finish Date	: 11-08-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00



CERTIFICATE OF COMPLIANCE

BON L CANADA INC

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cert. Date	Cert. No.	Sales Order	Page
11/13/05	130483	75470	1
Cust. PO	B/I No.	Lot	Date
2008873	00284675	75470010	11/13/05

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897105-2	190" Mill 6061 T6 ✓	D2500-1-190

Gross Weight	2165 LBS
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Net Qty	2,094 LB	77 PC	1219 FT	4 PKG
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Specification	Dis. Desc
AMS-QQ-A-200/8 & ASTM B221-00	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HR-E
1	323.6 / 47.0	294.4 / 42.7	8.6	.0	94
2	315.3 / 45.8	288.3 / 41.8	8.8	.0	94

Chemical Limits:

	SI	FE	CU	MN	MG	CR	ZN	TI	OTHER
MIN:	.400	.000	.150	.000	.800	.040	.000	.000	EA: .050
MAX:	.800	.700	.400	.150	1.200	.350	.250	.150	TOT: .150

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Conchita Ko, QA Manager Signed for Bon L Canada

Conchita Ko